

Work Order ID 79723-1

February-01-12 8:46:51 AM

SHIP TODAY

79723

Page 1

Item ID: D3041-1

Revision ID:

Item Name: Clamp

Start Date: 01/02/2012 Start Qty: 30.00

Required Date: 15/02/2012 Req'd Qty: 30.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.S

Date: 12/02/01 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

cut to meter

12/02/01

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio FA153

DWG REV:

FOLIO REV:

Machine per folio FA153

Machine per folio FA153

12/02/01

120

0.00

120

QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

Machine per folio FA153

12/02/01

Work Order ID 79723

February-01-12 8:46:51 AM

79723

Page 2

Item ID: D3041-1

Revision ID:

Item Name: Clamp

Start Date: 01/02/2012 Start Qty: 30.00

Required Date: 15/02/2012 Req'd Qty: 30.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC 8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

8 12/03/30

(x8)

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8 BR 12-3-30

150

QC 5- Inspect part completeness to step on W/O

0.00

150

QC

ax

Memo

0.00

Quality Control

8x8 m/l 12/03/30

Work Order ID 79723

79723

Page 3

February-01-12 8:46:51 AM

Item ID: D3041-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 01/02/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.00

Powder Coating

Mask inside of 0.8120" diameter hole
START TIME: 8h45
OVEN TEMPERATURE: 320°F
FINISH TIME: 9h15

M120 222

8 DP 12/03/30

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

8 BK 12-3-30

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D304
2- Stake bearing into place as per Dwg D304H

8 FF 12-03-30

Work Order ID 79723

February-01-12 8:46:51 AM

79723

Page 4

Item ID: D3041-1

Revision ID:

Item Name: Clamp

Start Date: 01/02/2012 Start Qty: 30.00

Required Date: 15/02/2012 Req'd Qty: 30.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

8/13/30

(48)

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

12/13/30

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCJ 12/03/30
MF
12-03-30

Picklist Print

February-01-12 8:46:54 AM

Page 1

Work Order ID: 79723

79723

Parent Item: D3041-1

D3041-1

Parent Item Name: Clamp

Start Date: 01/02/2012

Required Date: 15/02/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP RevA: as per revC1 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2611

Manufactured No

100

Each

34.0000

1

30

D2611

Bearing

**

(8) FF 12-03-30

Location

Loc Qty

Loc Code

ST012

34

77485

34

D2423

Manufactured No

180

f

385.5000

0.0833

2.630526

D2423

Lug Extrusion

**

CL 12102106

Location

Loc Qty

Loc Code

MAT006

385.5

43722

161.5

45800

1

68331

223

2.631

D3041-1

X 30

6443/30 (8)

DART AEROSPACE LTD		Work Order: 79723
Description: Clamp		Part Number: D3041-1
Inspection Dwg: D3041	Rev: C	Page 1 of 1

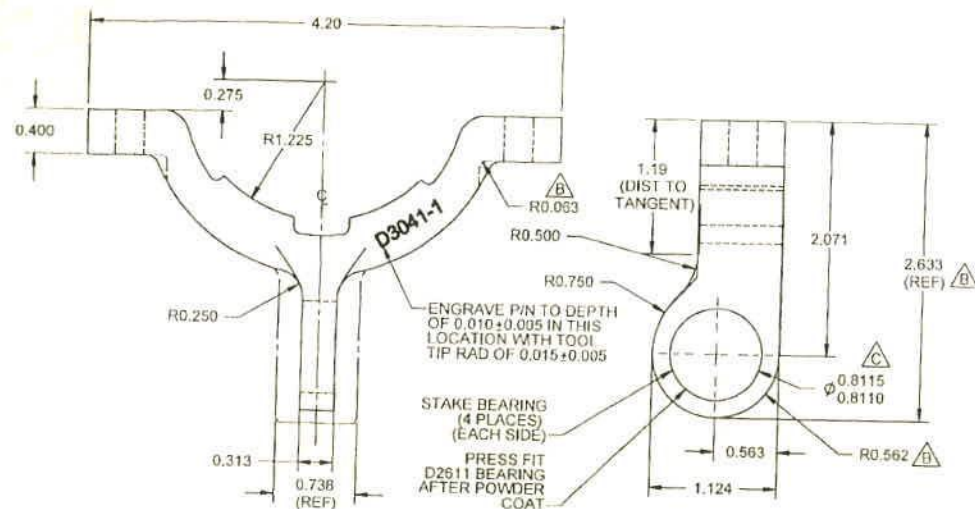
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030					
0.275	+/-0.010					
R1.225	+/-0.010					
0.400	+/-0.010					
R0.250	+/-0.010					
0.313	+/-0.010					
R0.063	+/-0.010					
1.19	+/-0.030					
1.124	+/-0.010					
0.563	+/-0.010					
R0.562	+/-0.010					
Ø0.8115 0.8110	N/A					
2.071	+/-0.010					
0.750	+/-0.010					
0.375	+/-0.010					
R0.338	+/-0.010					
3.450	+/-0.010					
Ø0.257	+0.005-0.000					
R0.375	+/-0.010					
0.375	+/-0.010					
R0.032	+/-0.010					
R0.250	+/-0.010					

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	

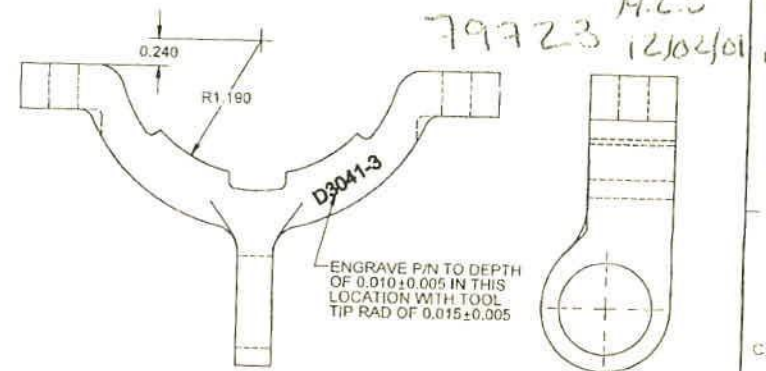
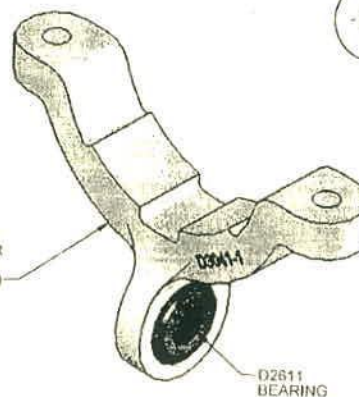


D3041-1 CLAMP

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

D3041-1 CLAMP (SHOWN) OR D3041-3 CLAMP (NOT SHOWN)



D3041-3 CLAMP
(SAME AS D3041-1 EXCEPT AS SHOWN)

DEO ATTACHED

RELEASED

06.11.17

REV	DATE	DESCRIPTION
C	06.10.16	CHANGED BEARING HOLE TOLERANCE
B	06.05.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL & D3041-54-7
A	01.06.28	NEW ISSUE
DESIGN	DRAWN BY	DESCRIPTION
901	CB	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
		SCALE 1:1

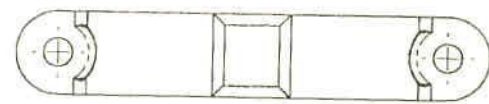
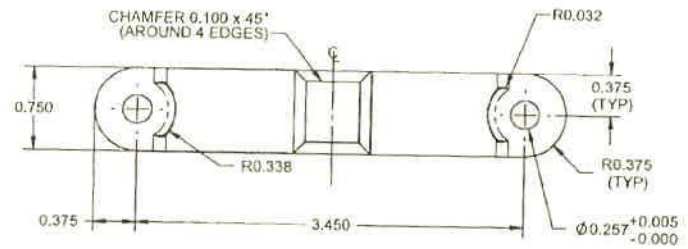
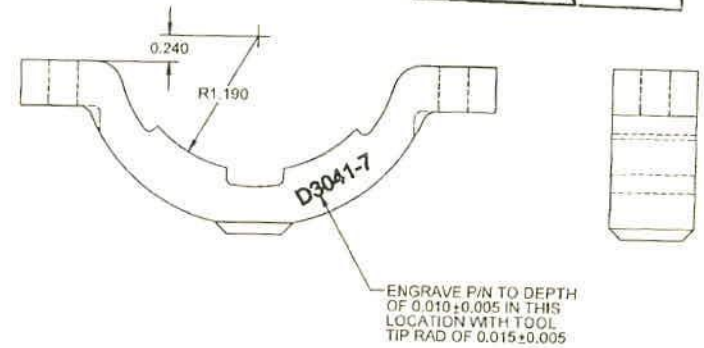
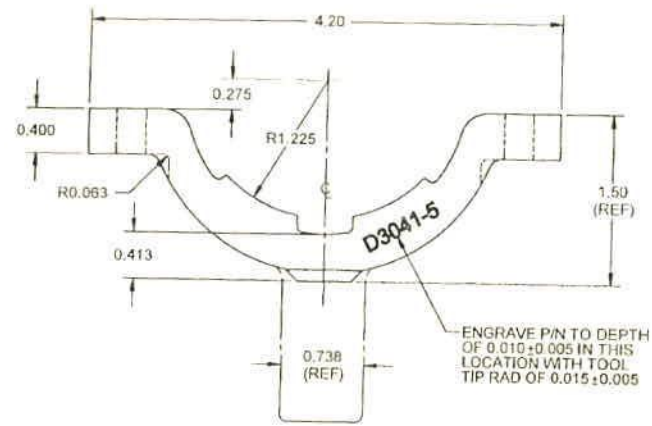
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.
THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.

79723

DEO ATTACHE

RELEASED

06.11.17

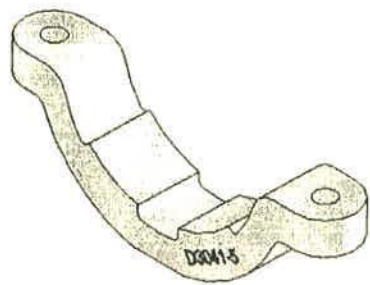


D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT C

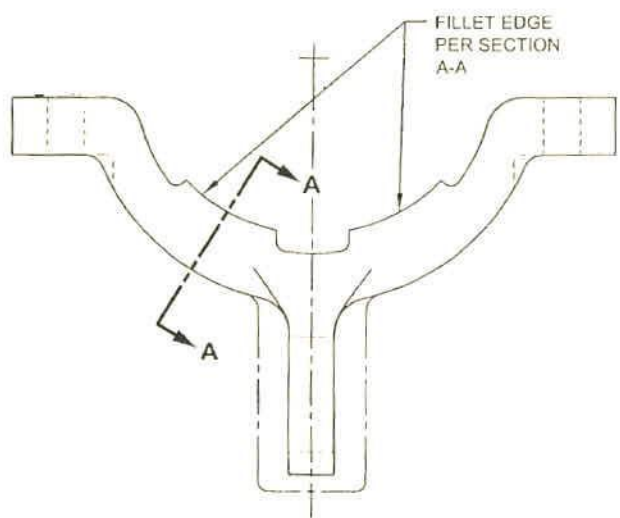


DESIGN 90	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3041	REV. C
DATE 06.11.18		TITLE CLAMP	SHEET 2 OF 2
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

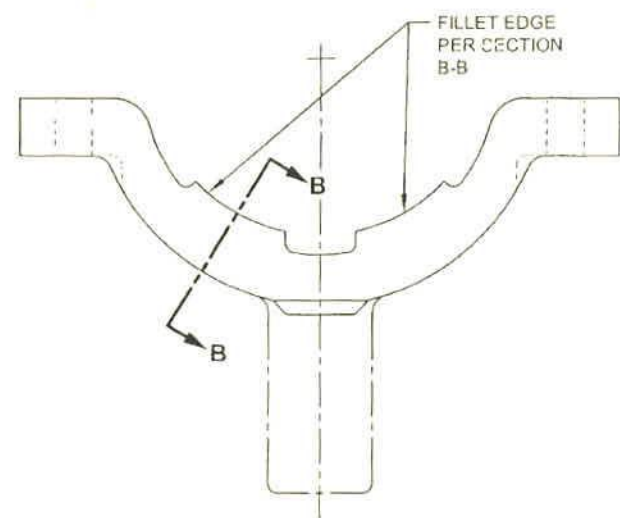
79763

DRAWING NO. D3041	TITLE CLAMP	REV: C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

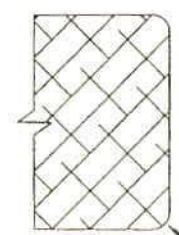
ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP
D3041-3 CLAMP



D3041-5 CLAMP
D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A
SCALE 2X
SECTION B-B
SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

COPYRIGHT © 2009 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16095

Purchase Order Date 2/06/12

PO Print Date 2/07/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-1P	Clamp	2/17/12 Yes	30.00 Each	Dart Truck	\$42.0000	\$1,260.00

Special Inst: AS PER DWG D3041 REV. C
B79723

PO Total:

\$1,260.00

Change Nbr:

2

Change Date: 2/07/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18495**
Date: Mar 29, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16095	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp	Each	30	8	22
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
8	D3041-1	Lug	16095

MATERIAL: supplied by DART B68331

S. Walz

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, March 29, 2012